

MAY 17 2018



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D119-646-012

Job Sheet 177605



Part No: D119-646-012

Job Qty: 1 ea

Part Name: AW119 Skidtube with Wearpads - RH



Part Weight: 0 lbs

Status: Scheduled

MAY 17 2018

JUN 01 2018

Priority: Medium

Job Created: 5/15/18

Job Tracking No:

Due Date: 6/5/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV D IPP RevA: New issue DD verified by:EC IPP REV:B 12.11.05 raise to chg002 (ECN 12-675) DD
verf:JLM IPP REV:C 13.03.20 raise to chg003 (ECN 13-534) DD verf:JLM IPP REV:D 14.11.25 IIN REV.C
(ECN 14-628) DD verf:JLM IPP REV:E 17.05.11 AS PER IIN REV.D DD verf:JFS

Ship Via:

Chg005 21 See attachment
DAS 10 9-89 3-89

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/5/18	6/5/18	0.00	0.00	Start Up Stores/Pkg-1		JUN 04 2018
110	Packaging	1 pcs	6/5/18	6/5/18	0.00	0.00	Packaging1-1		
120	QC	1 pcs	6/5/18	6/5/18	0.00	0.00	QC4		
125	DC	1 pcs	6/5/18	6/5/18	0.00	0.00	DC		
130	Packaging	1 pcs	6/5/18	6/5/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea	6/5/18	6/5/18	0.00	0.00	QC21		DAS 18-06-13 21 9-89

Part Op 125 - Photocopy bluefile & type labels per PPP D119-646-012
Descriptions: 130 - Identify and pack for shipping as per PPP D119-646-012

F9074 sold.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C50A	Bolt	8 Ea (8 ea)	110-Packaging	5019395
AN4C6A	Bolt	12 Ea (12 ea)	110-Packaging	5027515
D119-646-041	AW119 Replacement Skidtube with Wearpads - Fits LH or RH	1 Ea (1 ea)	110-Packaging	5059849
D119-646-311	Ground Handling	1 Ea (1 ea)	110-Packaging	5074013
D2652	Bushing	16 Ea (16 ea)	110-Packaging	5054604
D2712	Set Screw	12 Ea (12 ea)	110-Packaging	5031303
D3407-041	Tow Ring	1 Ea (1 ea)	110-Packaging	5058326
D3417-5	Washer	2 Ea (2 ea)	110-Packaging	5077284
D3456-1	Washer	1 Ea (1 ea)	110-Packaging	5077206
D3672-3	Washer, Phenolic	24 Ea (24 ea)	110-Packaging	5027022
D3672-7	Washer, Phenolic	24 Ea (24 ea)	110-Packaging	5077284
D3883-2	Saddle, Outside RH	2 Ea (2 ea)	110-Packaging	5064912
D3884-2	Saddle, Inside RH	2 Ea (2 ea)	110-Packaging	5070391
MS21043-3	Nut	8 Ea (8 ea)	110-Packaging	5034415
MS21043-4	Nut	13 Ea (13 ea)	110-Packaging	5056040
MS21250-05-006	Bolt	8 Ea (8 ea)	110-Packaging	FH132074
NAS1149C0332R	Washer	8 Ea (8 ea)	110-Packaging	5049837
NAS1149C0432R	Washer	24 Ea (24 ea)	110-Packaging	5050052
NAS1149C0532R	Washer	8 Ea (8 ea)	110-Packaging	5055951



Container No: S077177



Part: D119-646-012

Job No: 177605

Serial No/Batch: S077177

Revision:

Inspector:

Exp Date: 06/01/2018

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/01/18

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging	AN3C50A	8	78	0
	AN4C6A	12	391	0
	D119-646-041	1	12	0
	D119-646-311	1	1	0
	D2652	16	721	0
	D2712	12	797	0
	D3407-041	1	20	0
	D3417-5	2	8	0
	D3456-1	1	77	0
	D3672-3	24	1,164	0
	D3672-7	24	507	0
	D3883-2	2	8	0
	D3884-2	2	14	0
	MS21043-3	8	1,144	0
	MS21043-4	13	965	0
	MS21250-05-006	8	78	0
	NAS1149C0332R	8	5,512	0
	NAS1149C0432R	24	2,335	0
	NAS1149C0532R	8	357	0
Part Specifications				
Specifications could not be found.				

Plex 5/15/18 10:12 AM Dart.Gagnon.Michelle

DART aerospace		1270 ABERDEEN ST. HAWKESBURY ON CANADA K6A 1K7 TEL: 1-613-632-5200 www.dartaero.com	
PATENT	US #5735484 / CA #2222184 / EURO #0828655		
P.N	D119-646-041	CHG	CHG005
DESC	Replacement Skidtube STD	STC	SR02024SE
LOT	S059849	STC	
MODEL	Agusta A119/AW119MKII	STC	
TC APPROVAL # 09-89		MADE IN CANADA	
		D2729-4	

Item	Qty -011	Qty -012	Qty -111	Qty -112	Qty -211	Qty -212	Qty -041	Qty -141	Qty -151	Qty -241	Qty -251	Qty -311	Part Number	Description
71	8	8	8	8	8	8							MS21043-3	NUT
72	12	12	12	12	12	12							MS21043-4	NUT
73	12	12	12	12	12	12							D2712	SET SCREW
74	16	16	16	16	16	16							D3672-7	WASHER
75	24	24	24	24	24	24							D3672-3	WASHER
76	8	8	8	8	8	8							D3672-7	WASHER
80	1	1	1	1	1	1							D3407-041	TOW RING
81	2	2	2	2	2	2							D3417-5	WASHER
82	1	1	1	1	1	1							D3456-1	WASHER
83	1	1	1	1	1	1							MS21043-4	NUT
90												2	D3886-041	LUG ASSEMBLY
91												8	D2652	BUSHING
92												4	AN3C46A	BOLT
93												4	AN960C10L	WASHER (OR NAS1149C0332R)
94												4	MS21043-3	NUT
*120													MS21250-05048	BOLT
*121													NAS1149C0532R	WASHER
*122													D3672-7	WASHER
*123													MS21043-5	NUT

* SUPPLIED WITH DART CROSSTUBES

6.0 PARTS LIST

6.1 Standard Skidtubes

Item	Qty -011	Qty -012	Qty -111	Qty -112	Qty -211	Qty -212	Qty -041	Qty -141	Qty -151	Qty -241	Qty -251	Qty -311	Part Number	Description
	X												D119-646-011	STANDARD SKIDTUBE INSTALLATION WITH WEARPADS, LH
		X											D119-646-012	STANDARD SKIDTUBE INSTALLATION WITH WEARPADS, RH
			X										D119-646-111	STANDARD SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, LH
				X									D119-646-112	STANDARD SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, RH
					X								D119-646-211	STANDARD SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, LH
						X							D119-646-212	STANDARD SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, RH
	1	1					X						D119-646-041	REPLACEMENT STANDARD SKIDTUBE WITH WEARPADS
			1	1				X					D119-646-141	REPLACEMENT STANDARD SKIDTUBE WITH FULL LENGTH WEARPLATES & WEARPADS
									X				D119-646-151	WEARPLATE KIT STANDARD SKIDTUBE
					1	1				X			D119-646-241	REPLACEMENT STANDARD SKIDTUBE WITH TRAINING WEARPLATES
											X		D119-646-251	TRAINING WEARPLATES STANDARD SKIDTUBE
	1	1	1	1	1	1						X	D119-646-311	GROUND HANDLING KIT
1							1						D3887-041	STANDARD SKIDTUBE ASSY. WITH WEARPAD
20								1					D3887-043	STANDARD SKIDTUBE ASSY. WITH WEARPLATE & WEARPAD
26									1				D3847-043	FWD WEARPLATE ASSY
27									1				D3847-045	CENTER WEARPLATE ASSY
28									1				D3847-047	AFT WEARPLATE ASSY
29									5				D3847-1	WEARPAD
30									1				D3847-11	WEARPAD
31									30				AN3C5A	BOLT
32									30				AN960C10L	WASHER (OR NAS1149C0332R)
40										1			D3887-045	STANDARD SKIDTUBE ASSY. TRAINING WEARPLATE
44											1		D3849-041	FWD TRAINING WEARPLATE ASSY
45											1		D3849-043	AFT TRAINING WEARPLATE ASSY
51											16		D3904-1	WASHER
52											8		AN3C46A	BOLT
53											8		MS21043-3	NUT
60	2		2		2								D3883-1	SADDLE, OUTSIDE, LH
61		2		2		2							D3883-2	SADDLE, OUTSIDE, RH
62	2		2		2								D3884-1	SADDLE, INSIDE, LH
63		2		2		2							D3884-2	SADDLE, INSIDE, RH
64	16	16	16	16	16	16							D2652	BUSHING
65	8	8	8	8	8	8							AN3C50A	BOLT
66	12	12	12	12	12	12							AN4C6A	BOLT
67	8	8	8	8	8	8							MS21250-05006	BOLT
68	8	8	8	8	8	8							AN960C10L	WASHER (OR NAS1149C0332R)
69	24	24	24	24	24	24							AN960C416L	WASHER (OR NAS1149C0432R)
70	8	8	8	8	8	8							AN960C516L	WASHER (OR NAS1149C0532R)

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Revision: **D**
 Date: 17.02.21

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Part Number: D119-646-011/-012

Description: STD SKIDTUBE w/ WEARPADS, LH/RH

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								